

Date: Friday, 2/23/2007 8:31:37 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 STEP END PLATE
Job Number : 30883	
Estimate Number : 11021	
P.O. Number : <u>N/A</u>	Part Number : D2734
This Issue : 2/23/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2734 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 29340	Material : <u>N/A</u>
Written By : _____	Due Date : 3/30/2007 Qty: 200 Um: Each
Checked & Approved By : <u>[Signature] 07.02.23</u>	
Comment : Est:D 01.06.08 Removed Deburr EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.063" thick
 (M5052H32S.063) Batch: M19296

ml 07 02 27

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2734
 Dwg Rev: B
 Prog Rev: B

ml 07 02 27

SAD 07/02/27

07/03/05 Deburr

07/03/05 Nu

(200)
(200)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



ml 07 02 27

(200)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

(200) 07/03/05 Nu

07/02/28 (200)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form per drawing D2734

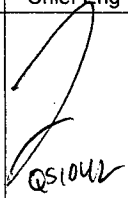
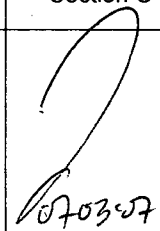
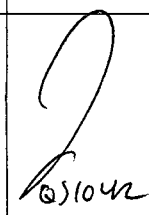

SB 07/03/07 199

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/08	5	1 part was out of tolerance part slide under the back step		Scrap + destroy	SK 07/03/08			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 STEP END PLATE

Job Number: 30883

Part Number: D2734

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (199)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/08 (199) W

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(199)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



W 07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

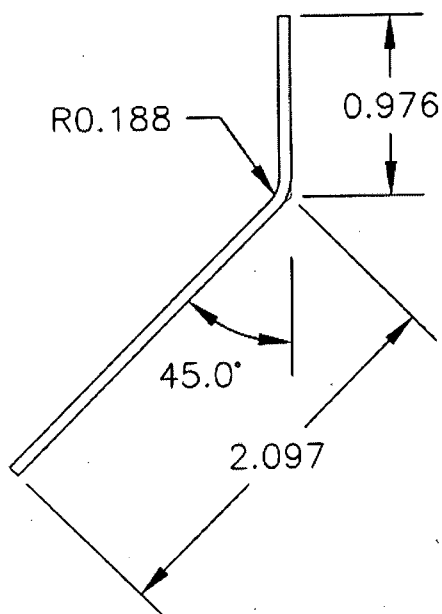
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

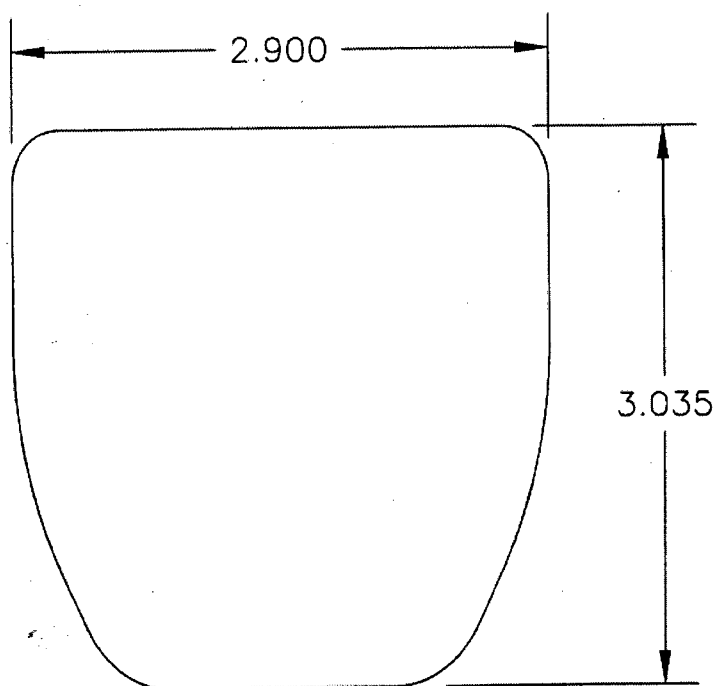


DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED RH	APPROVED SA	DRAWING NO. D2734	REV. B SHEET 1 OF 1
DATE 98.10.05	TITLE END PLATE		SCALE 1:1
A	97.12.10	NEW ISSUE	
B	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137	

RELEASED
98/10/05 KE



BEND DETAIL



FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR
6061-T6 (QQ-A-250/11) 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30883